Tuesday, 11/14/2006 10:08:43 AM Date: Kim Johnston User: **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number 29437 : 10503 **Estimate Number** : PCA : D2745 **Part Number** P.O. Number S.O. No. : NIP : D2745 REV B : 11/14/2006 **Drawing Number** This Issue : N/A **Project Number** Prsht Rev. : MACHINED PARTS Type **Drawing Revision** First Issue : JIA : 28974 Material **Previous Run** 150 Um: Each : 11/24/2006 Qtv: **Due Date** Written By Checked & Approved By Update to turn in house NG : Est C Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 303 Round Bar .75" M303R0750 1.0 Comment: Qty.: 0.1007 f(s)/Unit Total: 15.1043 f(s) 303 ROUND .75" Batch: M 109 318 Machine per Folio FA201 Material: AISI 303 SS HARDINGE CNC LATHE SMALL 2.0 HARDINGE comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Dwg D2515 150 2-Deburr INSPECT PARTS AS THEY COME OFF MACHINE 150 PARTS AS THEY COME OFF MACHINE Comment: INSPEC SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIÚM FAB RESOURCE 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr any sharp edges as per dwg

Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,				
Part No:		PAR #: Fault Category:	NCR: Yes	NCR: Yes No DQA: Da			0112/08
				N/C Close		Date:	

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)						
		Description of NC	(Corrective Action Section B	Verification	Annroval	Amproval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date:

Tuesday, 11/14/2006 10:08:43 AM

User:

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Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29437

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

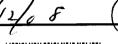
Comment: PACKAGING RESOURCE #1

Identify and Stock

Comment: FINAL INSPECTION/W/O RELEASE

Location:_

FINAL INSPECTION/W/O RELEASE



7.0

QC21



Job Completion



L 06,12.08

Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	4:	Date:	
			QA:	N/C Closed	d:	Date:	

NCR:		V	VORK ORE	DER NON-CONFORMANC	E (NCR)						
		Description of NC		Corrective Action Section B			Approval	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification A Section C	Chief Eng	Approval QC Inspecto			
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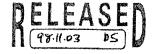
NOTE: Date & initial all entries

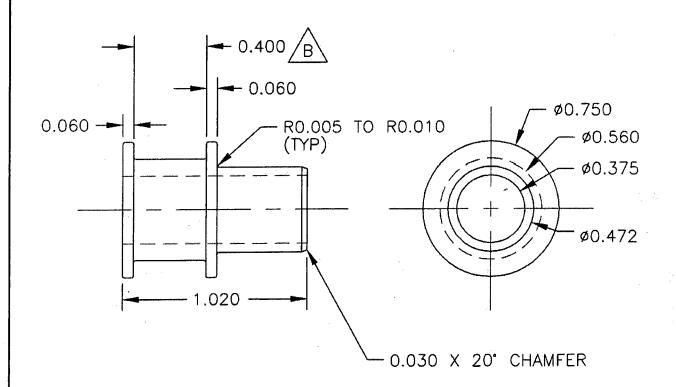
DART AEROSPACE LTD	Work Order:	29437
Description: Bushing	Part Number:	D2745
Inspection Dwg: D2745 Rev: B		Page 1 of 1

Inspection Dwg	g: D2745 F	Rev: B				Pag	gelori
	FIF	RST ARTICLE	INSPECT	TION CH	ECKLIST		
		X First A	rticle	Prot	totype		··· -
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
0.060	+/-0.010	.063					
0.400	+/-0.010	407					
0.060	+/-0.010	.060					
1.020	+/-0.010	1.035	./				
0.030 x 20°	+/-0.010	.030>26					
Ø0.472	+/-0.010	.472	/				
Ø0.375	+/-0.010	,373	/				
Ø0.560	+/-0.010	,561					
Ø0.750	+/-0.010	344					
		12 (0					
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Measured by:	2-1	Audited by:	51	- F	Prototype Ap	proval:	N/A
Date:	06/21/21	Date:	06/11/6			Date:	N/A
Rev Date	Change					Revised by	Approved
A 04.04.20	May Janua					KI/RE XIV	Tat:



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO. REV.	В
I M	1 KE	D2745 SHEET 1 OF	1
DATE		TITLE SCA	LE
98.10.23		BUSHING	2:1
А	98.04.16	NEW ISSUE	
В	98.10.23	DIM 0.400 WAS 0.380	





MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISETUNGTED RADIUS ALL INSIDE FOCES 0.005 TO 0.010

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.0200NTROLLED COPY SUBJECT TO AMENDMENT

ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE